

Date: Tuesday, 4/4/2006 1:36:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW LUG
 Job Number : 26536
 Estimate Number : 11217
 P.O. Number : N/A Part Number : D34041
 This Issue : 4/4/2006 S.O. No. : N/A Drawing Number : D3404 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 25119 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 4/24/2006 Qty: 60 Um: Each
 Checked & Approved By : 06.04.04
 Comment : Est Rev:A 05.00.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0750X2500 304 BAR .750 X 2.5



Comment: Qty.: 0.2406 f(s)/Unit Total : 14.4333 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: M19431 NO MORE MATERIAL

J.F. 06/04/08 55

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: 2.750" long

J.F. 06/04/08 55

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: B Folio Rev: AA

2-Deburr

J.F. 06/04/11 55

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/04/11 55

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/04/11 55

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 26/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 433

Shap/4/11 (55)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/04/11 (55)

Job Completion



u 06/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

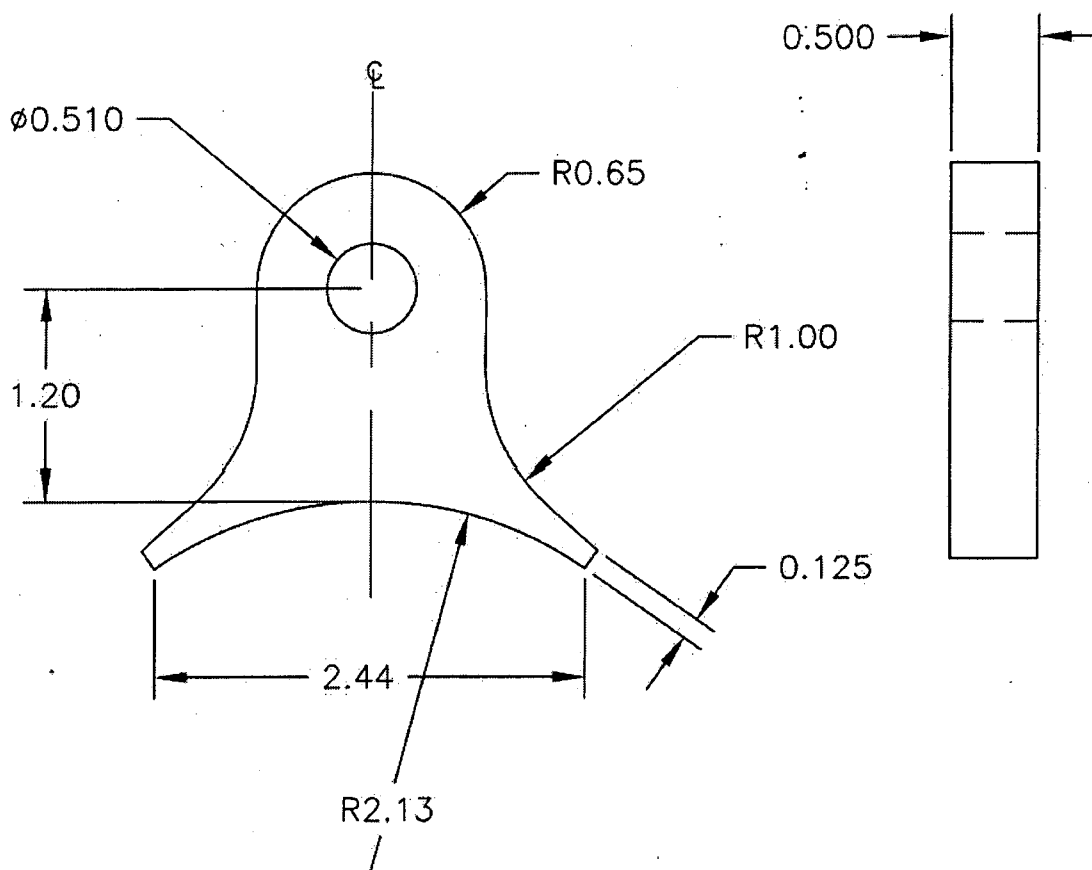
[illegible]

Measured by:	J.F.	Audited by:	J.G.	Prototype Approval:	N/A
Date:	06/04/08	Date:	06/04/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3404	REV. B SHEET 1 OF 1
DATE 05.06.14		TITLE GHW LUG	SCALE 1:1
A	05.03.08	NEW ISSUE	
B	05.06.14	UPDATE M-SPEC	

RELEASED
05-08-09 *[Signature]***D3404-1****D3404-1 GHW LUG**

- 1) MATERIAL: AISI 304/316 SS BAR
(REF. DART SPEC. M304B0.750X02.500)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP CORNERS 0.03 TO 0.06
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 26536

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